

Work Order ID 163032

Friday, August 11, 2017 8:28:31 AM

163032

Reprint

Page 1

Item ID: D3512-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 6/20/2017 Start Qty: 15.00

15

Cust Item ID:

Required Date: 6/24/2017 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 11 2017**

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3512

D

100

0.00

100

Waterjet

FLOW WATER JET

Memo

1.93

FLOW CNC Waterjet

1-Cut as per Dwg D3512

Dwg Rev: **P**Prog Rev: **P**

2-Deburr if necessary

16**17/08/11****DAS 40 9-89**

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.15

Quality Control

16**17/08/11****DAS 40 9-89**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 163032

163032

Parent Item: D3512-1

D3512-1

Parent Item Name: Wearplate

Start Date: 6/20/2017

Required Date: 6/24/2017

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD
13.12.11 ECN13-619/REV.D DWG DD VERF:JLM

IPP REV:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	137.7000	0.29	4.578948			
M304S16GA									**				DAS 40 9-89
304/316 Sheet .063												17/08/11	

Location

Loc Qty

Loc Code

MAT010

137.7

m138109

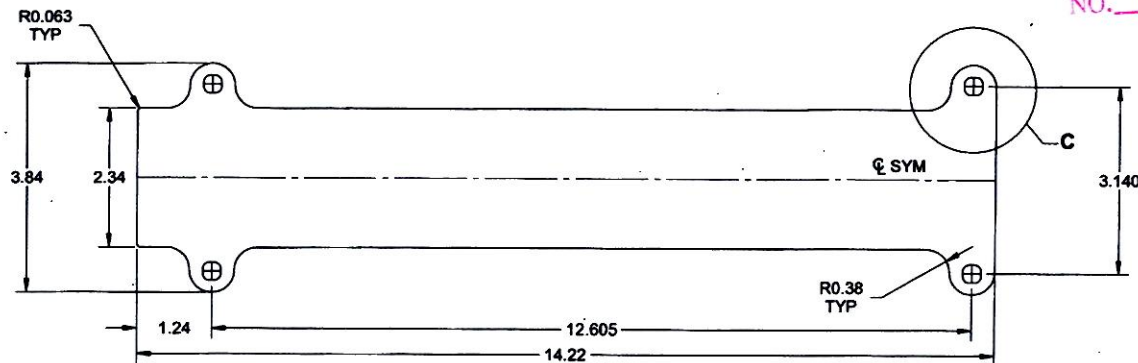
41.7

m138175

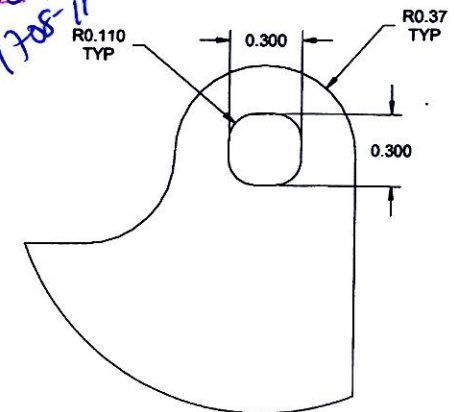
96

5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *163032 MCT*
1705-11



D3512-1F



DETAIL C
SCALE 2X

RELEASED
2013-12-10
WP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5058 OR AMS 5513 OR 5524 OR ASTM A240 18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	<i>AD</i>	DRAWING NO. D3512	REV. D
MFG. APPR.	<i>AD</i>	SHEET 3 OF 4	
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	